

Date: Tuesday, 10/06/2008 12:54:23 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HINGE BRACKET
Job Number :	39786		
Estimate Number :	10347		
P.O. Number :		Part Number :	D28572
This Issue :	10/06/2008	Drawing Number :	D2857 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	B
Previous Run :	36924	Material :	
Written By :		Due Date :	30/06/2008
Checked & Approved By :			Qty: 25 24 Um: Each
Comment :	: Est C 00.06.22 Removed P/O for powder coat EC : Est D 06.03.30 Added level 8 EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B2000X01250

6061-T6 Bar 2.0" x 1.25"



Comment: Qty.: 0.4594 f(s)/Unit Total : 11.0250 f(s)

Material: 2.00" X 1.25"

6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)

(M6061T6B200001250)

Batch ~~M6061T6B200001250~~

M105835

N.A

08/06/27

(25)

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks 5.2"

N.A

08/06/27

(25)

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2857-2

N.A

08/07/02

(25)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A

08/07/02 25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 39786

Part Number: D28572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 08/07/02

(25)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

N/A

5 08-07-02

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

FL

08/07/04

(25)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-07-07

(22)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

7:40

OVEN TEMPERATURE:

320

FINISH TIME:

8:10

FL

08/07/07

(25)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-07-07

(22)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5500

08/07/07 (25)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:24 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 39786

Part Number: D28572

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O 08.07.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39286
Description: Hinge Bracket		Part Number: D2857-2
Inspection Dwg: D2857 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

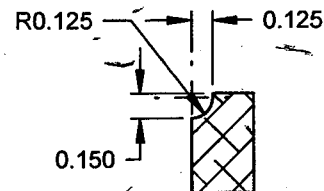
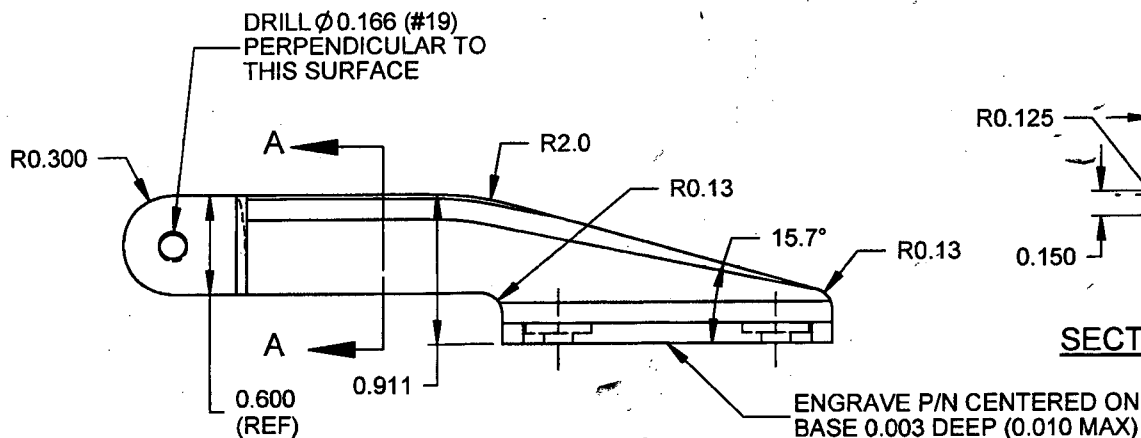
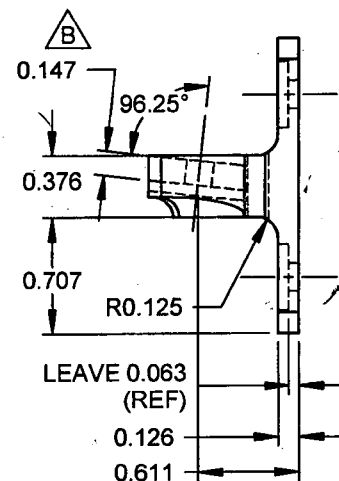
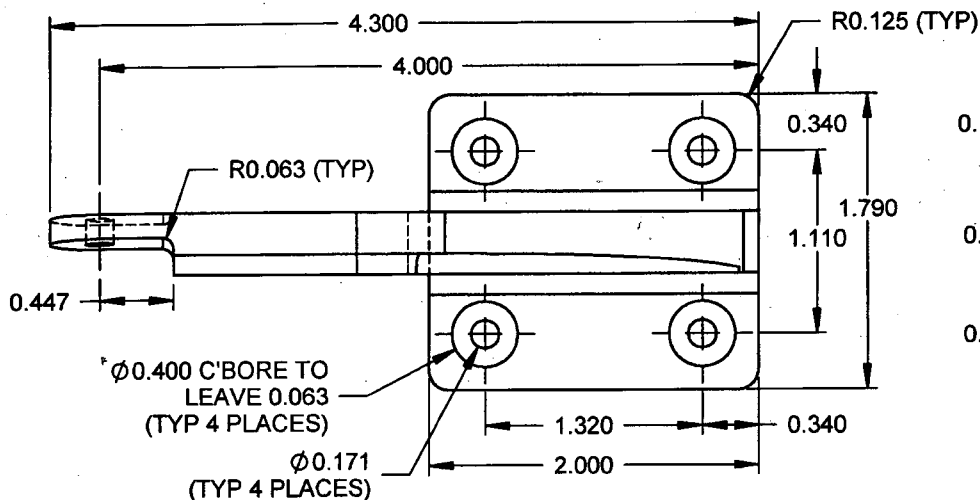
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.310	/			
4.000	+/-0.010	4.003	/			
0.340	+/-0.010	0.340	/			
1.110	+/-0.005	1.110	/			
1.790	+/-0.010	1.790	/			
1.320	+/-0.005	1.320	/			
2.000	+/-0.010	2.001	/			
0.340	+/-0.010	0.340	/			
0.447	+/-0.010	0.447	/			
Ø0.171	+0.005/-0.000	Ø0.171	/			
0.147	+/-0.010	0.144	/			
0.376	+/-0.010	0.378	/			
0.126	+/-0.010	0.125	/			
0.063	+/-0.010	0.063	/			
Ø0.166	+0.005/-0.000	Ø0.166	/			
0.911	+/-0.010	0.911	/			
0.600	+/-0.010	0.610	/			
0.125	+/-0.010	0.134	/			
0.150	+/-0.010	0.151	/			

Measured by: SA	Audited by: SS	Prototype Approval:	N/A
Date: 08/06/29	Date: 08/06/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

DART

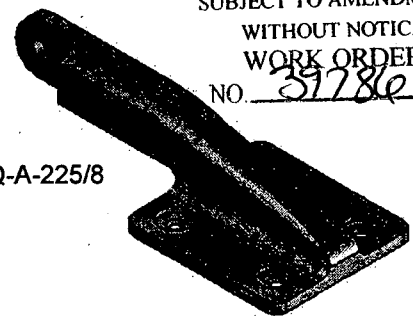
DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET	SCALE 1:1	
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

RELEASED
06-10-13**SECTION A-A**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *39780*

D2857-1 HINGE BRACKET
D2857-2 OPPOSITE**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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